## Work Order ID 60166-2

June 28, 2010 11:51:52 AM

Item ID:

D4134-041

Revision ID:

Item Name:

Wearplate, LH Aft

Start Date:

6/29/10

Start Oty: -2.00

Required Date: 7/15/10

Req'd Qty: 2.00



Accept



Setup Start



Page 1

Stop

Cust Item 1D:

Customer:

Toel ID

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling:

0.00

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Tool#

Plan

Code

Accept

Oty

Start Run

Reject

Qty



Stop

Reject

Number

Sequence ID/ Work Center ID Operation Description

Draw Nbr

Revision Nbr

D4134

A

100

Waterjet

FLOW CNC Waterjet

304 .050

FLOW WATER JET

Memo

1-Cut D4134; IF as per Dwg D4134

Dwg Rev: A

Prog Rev: 2-Deburr if necessary

QC2- Inspect parts off machine FAMFAIB

Memo

0.00

0.00

B10-6-29

1810-6-29

Insp.

Stamp

110

Quality Control

120

Quality Control

Inspect parts - second check

Memo

W/O:			W	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				et e					
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposit	ion:	QA: N/C CI	osed:		Date:	
NCR:		1	WORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign 8		cation	Approval	Approval
	3534343111	Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspector

oart Ae	rospace Ltd		8				
V/O:		WORK ORDER CHA	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	A)- QC In-
		n.					-
	2						

Part No: D 4134-041	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
/v.10.0b	100	Design changed. PARTS NO LONGER	V not	SCRAP PID.10.06 ( NEW PARTS MADE TO REV. B	D. 10.06	5 10/10/07	word	10.10.0
		CORRECT	10,000	TO REV. B	0.10.00	10/10/07	Male	
			7					
		9						

## Work Order ID 60166

June 28, 2010 11:51:52 AM

Item ID:

D4134-041

Wearplate, LH Aft

Revision ID:

Item Name:

6/29/10

Required Date: 7/15/10

OC:

Start Oty: 2.00 Reg'd Qty: 2.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Tool ID

Reference:

Start Date:

Approvals:

Process Plan:

Date: Date:

0.00

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Run Start

Reject

Qty

Accept

Qty



Stop

Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description

Form as per dwg

NC BRAKE

Dt 9641

Die as per Dwg D4134

Tool # Plan

Code

8 6.01.13 - ore only

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

P10.07.14 (

150

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch: Large Fab

0.00

0.00

Large Fab

Memo Weld hard surface using DT

as per OSI 004 and Dwg D4134

W/O:		WORK ORDER CHANGES	3				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/00/13	139	had to open Role at 311 to match with the jis	SB	12/07/13	3	Q 10 07.13 051 412	

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:	
Resolu	ution:	Disposition:	QA: N/C Closed:	Date:	

NCR:		WO	ORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B	Verification	n Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
		3						

#### Page 3

#### Work Order ID 60166

June 28, 2010 11:51:53 AM

Item ID:

D4134-041

Revision ID:

Item Name:

Wearplate, LH Aft

Start Date: 6/29/10 Start Qty: 2.00

Required Date: 7/15/10

Reg'd Qty: 2.00



Accept



Setup Start

Stop

Cust Item ID:

Customer:

Reference: Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Memo

Set Up/ Run Hours

0.00

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

0.00

Powdercoat

Grey Sandtex(Ref: 4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

Tool ID

Tool # Plan

Accept Qty Code

Qty

Reject

Reject Number Stamp

Insp.

170

180

Powder Coating

OVEN TEMPERATURE:

FINISH TIME:

oopace L	·u							4
		WO	RK ORDER CHANGE	S				
STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
:	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	A:	Date:	-
Reso	olution:	Disposition	:	QA: N/C Clo	sed:		Date:	
		WORK ORDE	R NON-CONFORMAN	NCE (NCR	)			
	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			Chief Eng	QC Inspector
	STEP	:PAR #: Resolution:  Description of NC	STEP PROCEDURE CHAN  PROCEDURE CHAN  PAR #: Fault Category  Resolution: Disposition  WORK ORDE  STEP Description of NC  Section A Initial	WORK ORDER CHANGE  STEP PROCEDURE CHANGE  :PAR #:Fault Category:  Resolution:Disposition:  WORK ORDER NON-CONFORMAN  STEP Description of NC Section A Section	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By  :PAR #:Fault Category:NCR: Yes II  Resolution:Disposition:QA: N/C Clot  WORK ORDER NON-CONFORMANCE (NCR  WORK ORDER NON-CONFORMANCE (NCR  STEP Description of NC Section A Initial Action Description Sign &	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date  :PAR #:Fault Category:NCR: Yes No DQ  Resolution:Disposition:QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty  : PAR #: Fault Category: NCR: Yes No DQA:  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  :PAR #:Fault Category:NCR: Yes No DQA:Date:

### Work Order ID 60166

June 28, 2010 11:51:53 AM

Page 4

Item ID:

D4134-041

Revision ID:

Item Name:

Start Date:

6/29/10

Required Date: 7/15/10

Wearplate, LH Aft

Start Qty: 2.00 Req'd Qty: 2.00

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Process Plan: Approvals:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ Work Center ID

190

Operation Description

QC3-Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan

Accept Qty

Code

Reject Qty

Reject Number Stamp

Insp.

Quality Control

200

Small Fab

Small Fab

0.00

0.00

Memo

1- Bond D4134-3 gasket to inner surface of wearplate using a thin layer of 3M

1300/1300L scotch grip adhesive

Batch:

210

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

W/O:			W	ORK ORDER CHANGES	6									
DATE	STEP	PRO	CEDURE CHA	NGE	By Date Qty Approva Chief Eng / Prod Mgr  NCR: Yes No DQA: Date: QA: N/C Closed: Date: NCE (NCR)  B Verification Approva		Approval Chief Eng / Prod Mgr	Approval QC Inspector						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _						
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _						
NCR:		,	WORK ORD	ER NON-CONFORMAN	CE (NCR	1)								
DATE	STEP	Description of NC		Corrective Action Section	Ver		ication	Approval	Approval					
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sec	tion C	Chief Eng	QC Inspector					
									_					

#### Work Order ID 60166

June 28, 2010 11:51:54 AM

Item ID:

D4134-041

Revision ID:

Item Name:

Wearplate, LH Aft

Start Date:

6/29/10

QC:

Start Qty: 2.00

Required Date: 7/15/10

Req'd Qty: 2.00



Accept

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/ Work Center ID

220

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Packaging

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code Qtv

Reject Accept Qty

Reject Number Stamp

Insp.

230

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

mf 10-15-04

Dart Aei	rospace	e Ltd							10
W/O:			WC	ORK ORDER CHANGES	5			-	
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	R	tesolution:	Disposition	n:	QA: N/C C	losed:		Date:	
NCR:		V	VORK ORDI	ER NON-CONFORMAN	CE (NCF	R)			
		Description of NC		Corrective Action Section 8	3	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a	& Sect	ion C	Chief Eng	QC Inspector

### **Picklist Print**

June 28, 2010 11:51:51 AM

Work Order ID: 60166

Parent Item:

D4134-041

Parent Item Name: Wearplate, LH Aft



Start Date: 6/29/10

Required Date: 7/15/10

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A 10.06.25 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4134-3 Gasket	III	Manufactured	No			200	Each	0.0000	1	2.000200			
M304S18GA		Purchased	No			100	sf	132.8779	1.5825	3.165317	4.8		
304/316 .050 Sheet				Location		Loc O	tv	Loc Code		G	310-6	24	

Location Loc Qty Loc Code MAT20 132.8779 111743 8.86 112885 28.0179 113062 96

rospace Lt	td							68.0 10
		WC	ORK ORDER CHANGES					
STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	DAD #	Equit Cata	norw: NC	*P: Vas	No. BO	Δ.	Date	
nesc							Date	
	Description of NC		Corrective Action Section B		Verifi	cation	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description  Chief Eng		Sec		Chief Eng	QC Inspector
	STEP	PAR #:  Resolution:	STEP PROCEDURE CHA  PROCEDURE CHA  PAR #: Fault Cate  Resolution: Dispositio  WORK ORD  STEP Description of NC Section A Initial	WORK ORDER CHANGES  STEP PROCEDURE CHANGE  PAR #: Fault Category: NO  Resolution: Disposition: QA  WORK ORDER NON-CONFORMANC  STEP Description of NC Section A	STEP PROCEDURE CHANGE By  PAR #: Fault Category: NCR: Yes  Resolution: Disposition: QA: N/C CI  WORK ORDER NON-CONFORMANCE (NCF  STEP Description of NC	STEP PROCEDURE CHANGE By Date  Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Section B	STEP PROCEDURE CHANGE By Date Qty  DESCRIPTION OF NC Section A Section C Sec	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr  D:PAR #:Fault Category:NCR: Yes No DQA:Date:

DART AEROSPACE LTD	Work Order: 60166
Description: WEAR PLATE LH AFT	Part Number: D4134 -041
Inspection Dwg:D 4134-1 Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1300	4 00	,303				
.300	4- 06	.343		*		
,415	4 .010	.412				<i>Y</i> )
-82	4 .030	.816				T
2.74	44 .030	2.724			Tile	
4.65	1 030	4,640			-	
	7 -010	5.053			-	
	·L -030	5.468		1	1	
\$ .203	1.005-001	.205	- 1		Ta. I	
.375	12 WD	.374				
5.84	46 030	5.85				
8-24	th .010	8-268	1			
13.170	Y310	13.170				
15.85	4 .03	14.85	1 11			
18.092	4/ 1010	18.092				
23.03	4- 010	23.013				
25.86	4 .630	25.85				
27.934		27934			1	
28-31		28.310			-	
8.05	T .030	8.048				25
15.73	42 ,030	15.73				
15.98	T .030	15.98			-	
-050	T .010	.oso				

Maggurad by:	70	Audited by:	Prototype Approval:	N/A
Measured by:	K		Date:	N/A
Date:	10-6-29	Date: 10/04/3	Bate.	1427

	<b>5</b> (	Change	Revised by Approved
Rev	Date	Change	KJ/JLM
A		New Issue	10/02/0

Di

**ENGINEERING** UNCONTROLLED COTT 4SUBJECT TO AMENDMENT QTY QTY PART NUMBER DESCRIPTION

VALUE OF THE PART NUMBER DESCRIPTION

VALUE OF THE PART NUMBER DESCRIPTION

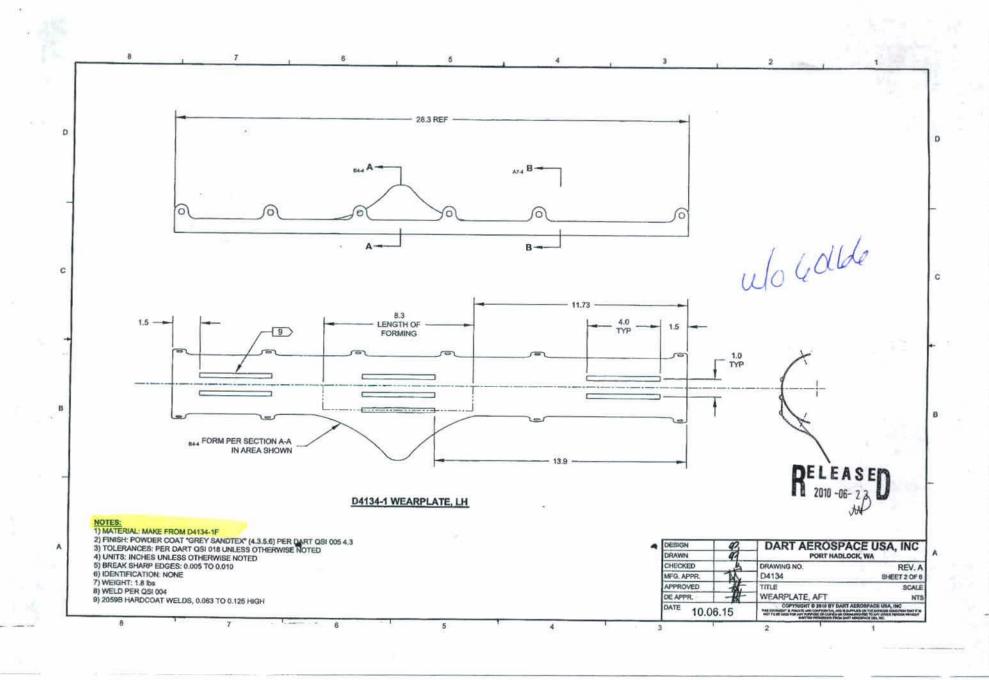
VALUE OF THE PART NUMBER DESCRIPTION WEARPLATE, LH AFT WEARPLATE, RH AFT D4134-042 D4134-1 WEARPLATE 1 D4134-2 WEARPLATE 1 1 D4134-3 A/R A/R 1300 / 1300L 3M SCOTCH-GRIP ADHESIVE D 8 D4134-3 GASKET D4134-1 WEARPLATE D4134-041 WEARPLATE, LH AFT D4134-3 GASKET B D4134-2 WEARPLATE D4134-042 WEARPLATE, RH AFT A NEW ISSUE CP 10.06.15 1) MATERIAL: N/A REV. DESCRIPTION BY DATE 2) FINISH: N/A 3) TOLERANGES: PER DART QSI 018 UNLESS OTHERWISE NOTED DESIGN DART AEROSPACE USA, INC. 4) UNITS: INCHES UNLESS OTHERWISE NOTED DRAWN PORT HADLOCK, WA 5) BREAK SHARP EDGES: N/A CHECKED DRAWING NO. REV. A 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4134-xxx" USING YELLOW PAINT MARKER ON INSIDE SURFACE MFG. APPR. D4134 SHEET 1 OF 6 7) WEIGHT: -041/-042 = 2.2 lbs APPROVED TITLE SCALE 8) BOND D4134-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE DE APPR WEARPLATE, AFT NTS DATE 10.06.15

SHOP CULY RETURN TO

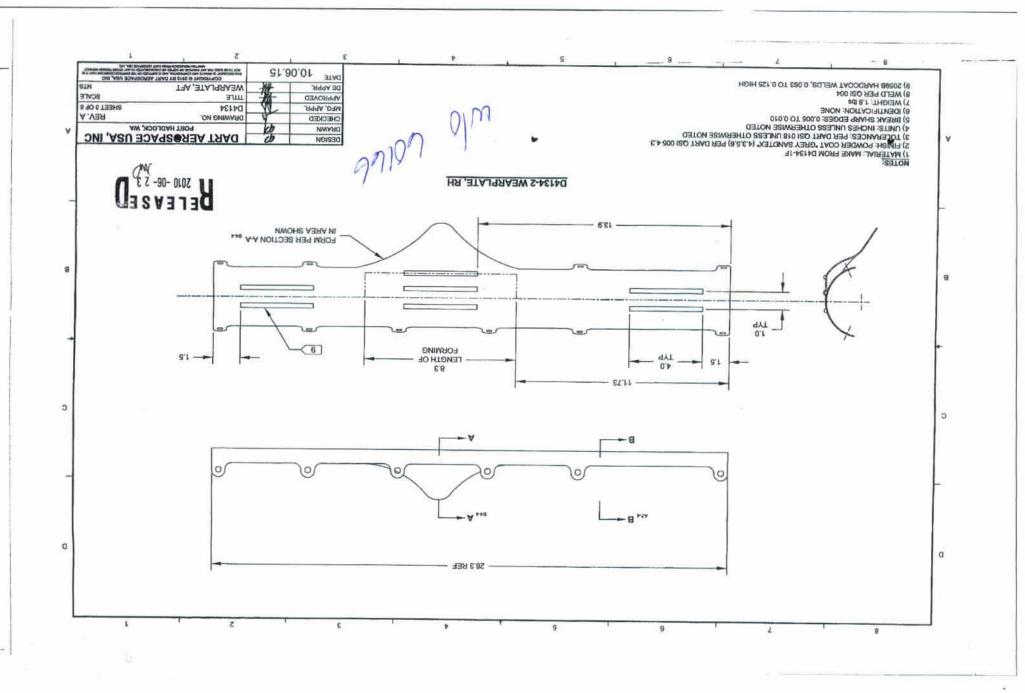
Dart A	Aerospace	Ltd
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Dart Ae	rospace Ltd							
W/O:			WORK ORDER	CHANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	DAD #-	Fault Category:	NCP: V	ns No DO	Δ.	Data	
						10.04110.00	The second second	
	Resolution	n:	Disposition:	QA: N/C	QA: N/C Closed:			
NCR:			WORK ORDER NON-CON	FORMANCE (N	CR)			

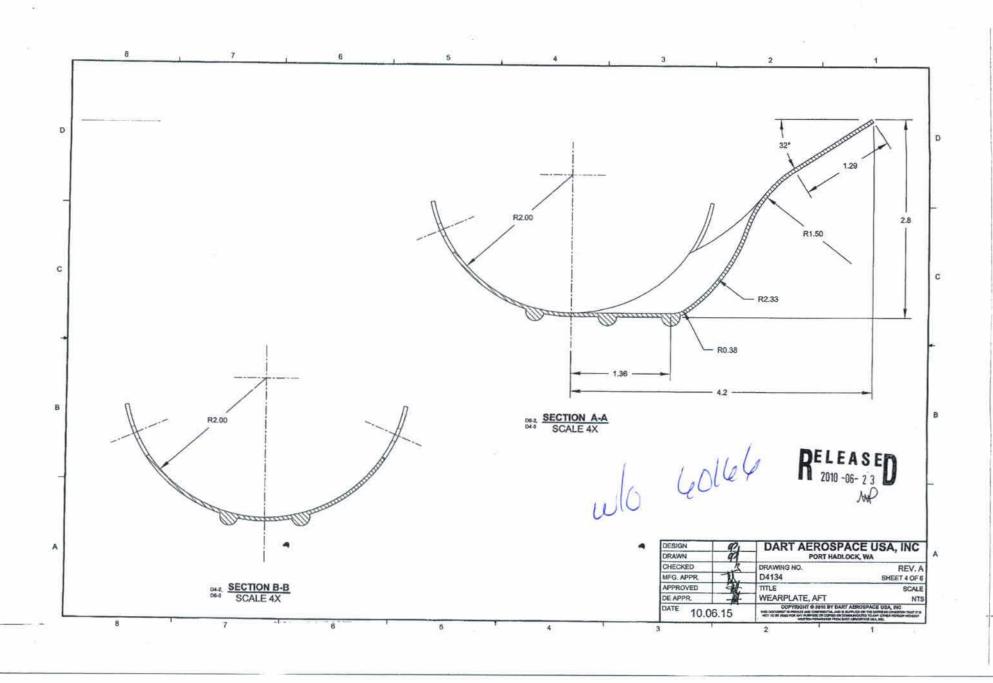
NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Annroyal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspecto		
						_	_			
				19						



Dart Ae			14/0	DE OBDED CHANC	EC				
W/O:	CTED	WORK ORDER CHANGES				Dete	Otro	Approval	Approva
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Chief Eng / Prod Mgr	QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No D	QA:	Date: _	
	Res	olution:	Disposition	1:	QA: N/C	Closed: _		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (N	CR)			
DATE	OTED	Description of NC		ion B	Ver	fication	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n& Se	ection C	Chief Eng	QC Inspector

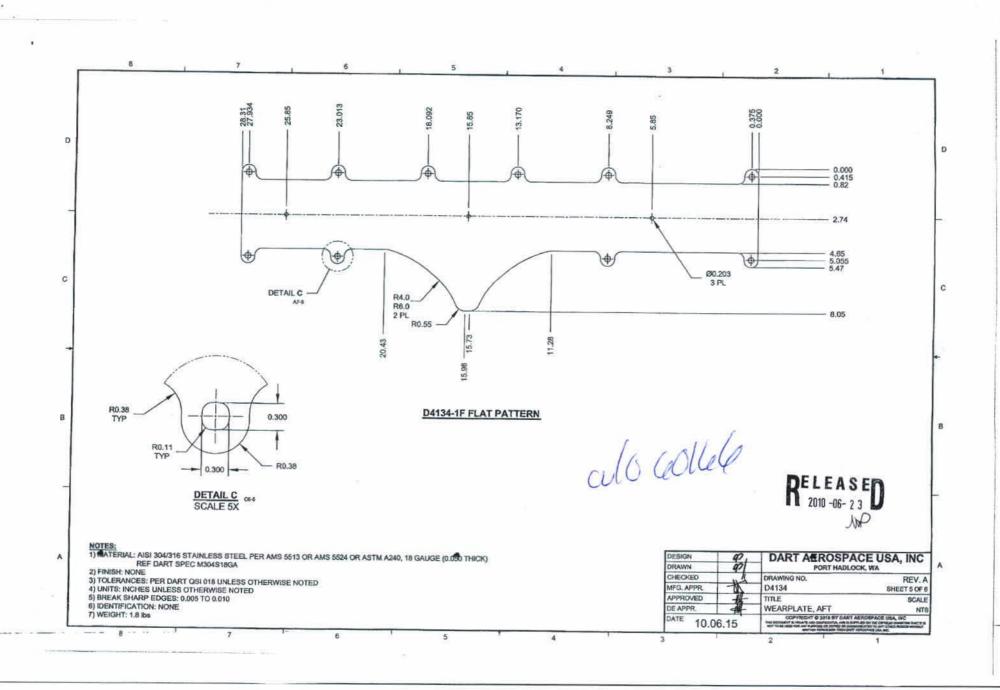


Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Corrective Action Section B Verification Approval Appr	Aerospace L	erospac	ce Ltd							
Part No:				W	ORK ORDER CHANGES	5				
NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Portion Section B Section C Chief Eng Conference Confer	E STEP	STEP	PR	OCEDURE CH	CEDURE CHANGE			Qty	Chief Eng /	Approva QC Inspector
Resolution:										
NCR: WORK ORDER NON-CONFORMANCE (NCR)  DATE STEP Description of NC Section A Portion A Portion C Section A Portion C Section A Portion C Chief Eng C C	No:	o:	PAR #:	Fault Cat	egory: N	ICR: Yes	No <b>DQ</b>	A:	Date:	
DATE STEP Description of NC Section A Poroval Initial Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Chief Eng Or Corrective Action Description Sign & Section C Corrective Action Description Sign & Section Descripti	Res	F	Resolution:	Disposition:		QA: N/C Closed:			Date:	
DATE STEP Description of NC Section A Initial Action Description Sign & Verification Approval A Chief Eng Co.	:			WORK OR	DER NON-CONFORMAN	CE (NCR	)			
Section A Initial Action Description Sign & Section C Chief Eng Or			Description of NC	Corrective Action Sec			Verification		Ammental	Approva
	TE STEP	STEP	Section A			on Sign & Section		Section C		QC Inspecto

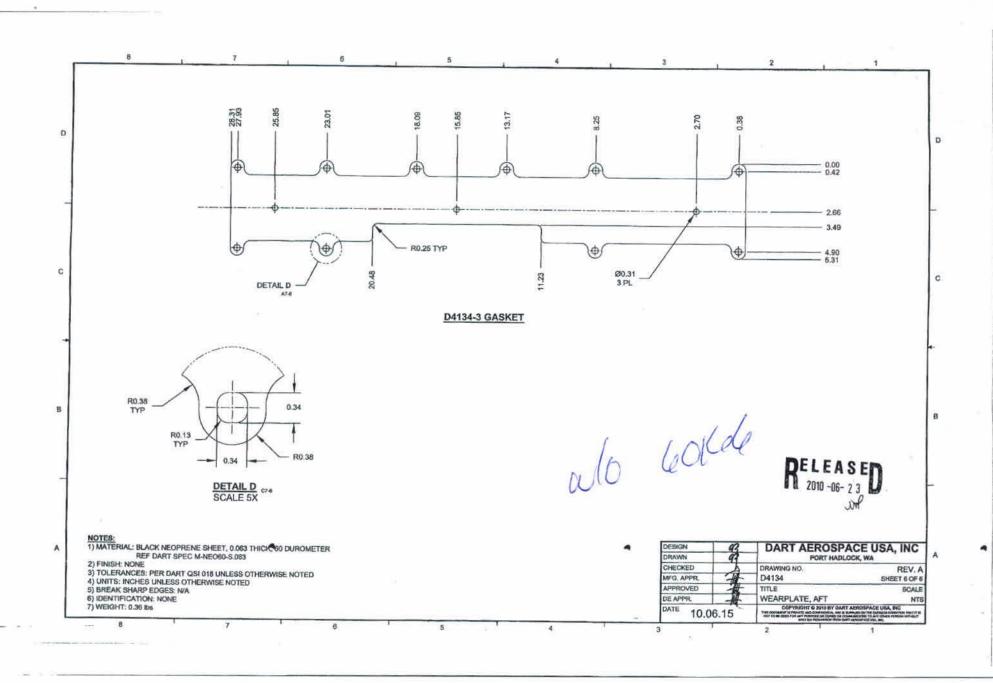


W/O:		I F	WORK ORDER CHANGES					
DATE	STEP	PF	ROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	):	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition:	QA: N/C	Closed:		Date: _	

NCR:			WORK ORD	ER NON-CONFORMANO	E (NCR)			
		Description of NC	Corrective Action Section B			Verification	Annessal	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Dart Ae	rospace	e Ltd							•
W/O:			٧	ORK ORDER CHANGES					ν.
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:				tegory: NC					
NCR:		V	VORK OR	DER NON-CONFORMANC	E (NCF	<b>?</b> )			
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verific		Approval	Approval
			Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector



W/O:		WORK ORDER CHA	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	): 	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:			

Disposition: \_

QA: N/C Closed: \_\_\_\_\_

Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC Section A	Corrective Action Section B			Verification	Annroval	Annuaval			
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			

NOTE: Date & initial all entries

Resolution: \_